

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1x.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026804**Date Inspected:** 02-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Bernie Docena**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Bike Path - Skyway**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Art Peterson arrived on the jobsite between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by American Bridge Fluor (ABF) personnel on the Skyway portion of the SFOBB. The following observations made were for extra work being performed to the following contract change orders:

CCO: 178 - Description: Modify the existing Bike Path belvederes, Bike Path maintenance traveler, and existing maintenance traveler rail to allow passage of the traveler on the Skyway portion of the East Span SFOBB.

This QA Inspector randomly observed ABF welder Mr. Gil Peralta performing the Air-Carbon-Arc gouge operation to remove the remnant material - (at least 10 mm of material) of the section of the architectural beam that was previously removed by others from the bottom panel of the Bike Path at Pier Location 10E - (east side location). This QA Inspector observed that there was one (1) area on the bottom panels' base metal that was gouged into from the Air-Carbon-Arc gouge operation that required weld repair from the removal of the portion of the architectural beam. After the base metal was repaired per the SMAW process in the overhead position by ABF Welder Gil Peralta (Welder ID 9543), the repaired area was ground flush and smooth to the base metal surface.

Afterwards, this QA Inspector randomly observed ABF welder Mr. Gil Peralta (Welder ID 9543) performing the fillet weld operation on the six (6) mm thick cover plate to cover the opening in the architectural beam of the belvedere at Pier Location 10E per the Shielded Metal Arc Welding (SMAW) process in the (3F) vertical and (4F) overhead positions.

This QA Inspector observed QC Inspector Mr. Bernie Docena verify prior to the start of the fillet weld operation

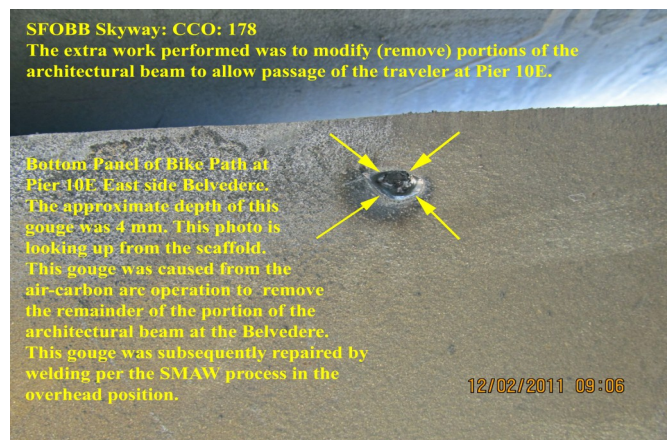
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that the preheat temperature of 70 degrees F was established and afterwards verified that the welding parameters (Amps, Volts and Travel Speed) were in accordance with WPS-F1200A. After the fillet weld operation was completed connecting the cover plate to the end of the opening in the architectural beam, this QA Inspector observed QC Inspector Mr. Bernie Docena; perform a visual inspection of the fillet weld to verify the fillet weld size and weld quality. The fillet weld size and quality visually appeared to be in general compliance with AWS D1.5-2002 Section 3.6 and 6.26.

This QA Inspector also witnessed the magnetic particle inspection on 100% of the length of weld connecting the cover plate to the opening in the architectural beam using the yoke method in conformance with ASTM E709 and the standard of acceptance in conformance with AWS D1.5-2002 Section 6.26.

This QA Inspector also observed ABF personnel performing the drilling operation for the installation of additional mounting bolts - (19 mm diameter) thru the existing box girder web plate of the Bike path box girder and thru the Bike Path maintenance traveler outer rail. This QA Inspector observed that the ABF personnel were in-process on the drilling operation and were working towards Pier location 10E by the end of this QA Inspectors' shift.



Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or

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remedial efforts please contact Nina Choy, 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Peterson, Art	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
